

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024122**Date Inspected:** 27-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Shi Yu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector observed the following work in progress for Bay 1.

ZPMC perform FCAW welding on lifting lug and grinding work on the hand rail and lifting lug,

Bay 7

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; Bike Path on item number 1 of NWIT tracker document # 09275,

Bay 8

This QA Inspector observed the following work in progress for Bay 8.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Huang Min.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: U-Rib splice channel

WELDING INSPECTION REPORT

(Continued Page 2 of 5)

PCMK: SA2310-1-2

Welder: 054459

WPS-B-P-2231-TC-U4b-FCM-1

Bay 9

This QA Inspector observed the following work in progress for Bay 9.

ZPMC perform fit up and grind work on Traveler rail and U-Rib splice channel.

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC perform fit up and grind work on bike path BK011A.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as An Gian Xing.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: Traveler Rail

PCMK: TR3007TR1

Welder: 037779

Report: BWR-21117

WPS-345-SMAW-2G (2F)-repair-1

Components: Sub Assembly

PCMK: X4025C-001-001

Welder: 045268

Report: BWR-21117

WPS-345-SMAW-3G (3F)-repair-1

Heat straightening of PCMK, TR3008TR2, TR3021TR1, under approved Heat Straightening procedure, HSR 1 (B)-10279, 10279 The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as An Gian Xing. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC perform SMAW VT repair welding and grind work on hand rails.

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC perform FCAW welding on lifting lug and grinding work on the BK24A3,

WELDING INSPECTION REPORT

(Continued Page 3 of 5)

Trial Assembly Yard

This QA Inspector observed the following work in progress for Trial Assembly yard.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhang Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: 13AW

PCMK: FB3193-001-149, 156

Welder: 201861

WPS-B-P-2113-FCM-1

Components: 13AW

PCMK: DP3120-001-011

Welder: 066674

Report: BWR20560

WPS-345-SMAW-3G (3F)-FCM-Repair-1

Components: 13CW

PCMK: SEG3020AW-086,

Welder: 070008

WPS-B-P-2114-FCM-1

Components: 13CW

PCMK: OBW13-001

Welder: 201861

Report: BWR 21111

WPS-345-SMAW-4G (4F)-FCM-Repair-1

Components: 13BE

PCMK: SEG3009D-066,072

Welder: 052696

Report: BWR 21111

WPS-345-SMAW-3G (3F)-FCM-Repair-1

Components: 13BE

PCMK: AH3512A-008

Welder: 051354

WPS-B-P-2212-B-U2-FCM-1

Components: 13B/C

PCMK: OBE13AA-003,004

Welder: 067866

WELDING INSPECTION REPORT

(Continued Page 4 of 5)

WPS-B-P-2114-FCM-1

Components: 14E

PCMK: SEG3019AJ-069,080

Welder: 215553

Report: BWR 21606

WPS-345-SMAW-3G (3F)-FCM-Repair-1

Components: 14E

PCMK: SEG3019AL-004,295

Welder: 067611, 216086

WPS-B-P-2212-TC-U4b-FCM-1

Components: 14E

PCMK: SEG3019G-089

Welder: 058087

WPS-B-P-2214-TC-U45-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhang Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13AW

PCMK: SEG3013AP-27, 28

Welder: 048433

WPS-B-T-2132-ESAB

Components: 14E

PCMK: SEG3019AV-055

Welder: 068494

Report: BWR 21066

WPS-345-SMAW-2G (2F)-FCM-ESAB-Repair-1

Components: 13BE

PCMK: SEG3007F-067,071

Welder: 055491

WPS-B-T-2231-ESAB

Components: 13BE

PCMK: SA3037-007,008

Welder: 050977

WPS-B-T-2231-ESAB

WELDING INSPECTION REPORT

(Continued Page 5 of 5)

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; OBG 14E on item number 1 of NWIT tracker document # 09277,

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
